

Work Order ID 60931

Tuesday, July 27, 2010 10:58:10 AM



Page 1

Item ID: D3282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Web (206L/407)

Start Date: 7/27/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

H

Date:

10-7-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3282	Rev C

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut to length as per Dwg D3282.
per QSI0018

☐ 2- inspect for surface damage as

C *--- dwm*
10-07-30

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA579 & Dwg D3282 ☐ 2-Deburr

G.A 10/10/27

6 *Ø*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

G.A 10/10/27

6 *Ø*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 8/3/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo 	0.00 0.00				6	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		SAD 20-10-01		6			
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				6	0	BE 10/11/01	

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Page 4

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Start Date: 7/27/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 10/11/02 [Signature]
MF
10-11-3

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Picklist Print

Tuesday, July 27, 2010 10:58:16 AM

Page 1

Work Order ID: 60931

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 7/27/2010

Required Date: 8/3/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:B 05.09.23 Procedure change KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20470AD4-7

Purchased

No

100

Each

1,259.000

57

342



Rivet, Universal Head



SAD 10-11-01

Location

Loc Qty

Loc Code

ST320

1259

112492

1259

342

D2792-130

Manufactured

No

160

Each

8.0000

1

6



EXTRUSION

Location

Loc Qty

Loc Code

MAT06

8

42366

8

ALW 10-07-30 E

D3283-1

Manufactured

No

160

Each

4.0000

2

12



Doubler

SAD 10-01-01 (6)

Location

Loc Qty

Loc Code

ST048

4

57725

4

B60203

12

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	60931
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.610	✓		Tape	GA-12
1.500	+/-0.010	1.500	✓		Vern	GA-01
3.000	+/-0.010	3.000	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
1.250	+/-0.010	1.250	✓		"	"
30.000	+/-0.010	30.000	✓		Tape	GA-12
1.500	+/-0.010	1.500	✓		Vern	GA-01
72.01	+/-0.030	72.010	✓		Tape	GA-12
61.75	+/-0.030	61.750	✓		"	"
57.50	+/-0.030	57.500	✓		"	"
49.19	+/-0.030	49.190	✓		"	"
43.94	+/-0.030	43.940	✓		"	"
39.69	+/-0.030	39.690	✓		"	"
26.68	+/-0.030	26.680	✓		"	"
0.55	+/-0.030	0.552	✓		Vern	GA-01
1.970	+/-0.010	1.961	✓		"	"
2.38	+/-0.030	2.376	✓		"	"
0.05	+/-0.030	0.056	✓		Depth gage	GA-08

Measured by:	H.A	Audited by:	SA	Prototype Approval:	N/A
Date:	10/10/27	Date:	10/11/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	SA

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DART

SHED BY
R
EN

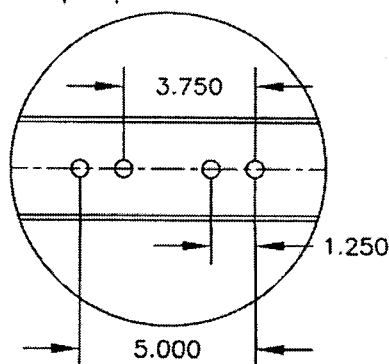
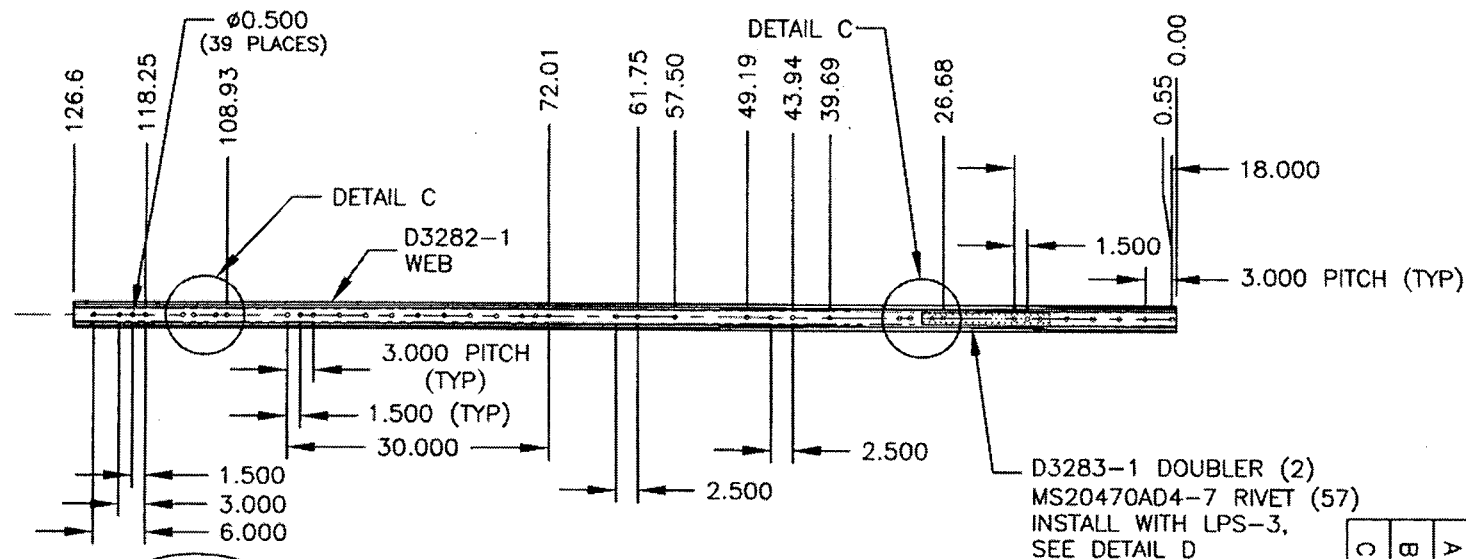
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SUBJECT

WITH
WORK ORDER

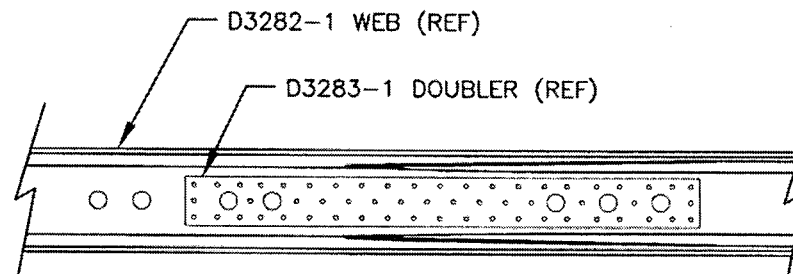
NO. 60931

BF10-7-27

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3282
DATE	TITLE	REV. C
05.08.09	FLOAT WEB, 206L/407	SHEET 1 OF 2
A	04.05.05	NEW ISSUE
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS
C	05.08.09	REMOVE D3390-1, NOW MACHINED



DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY



DETAIL D
SCALE 1:5

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

RELEASED

05.09.12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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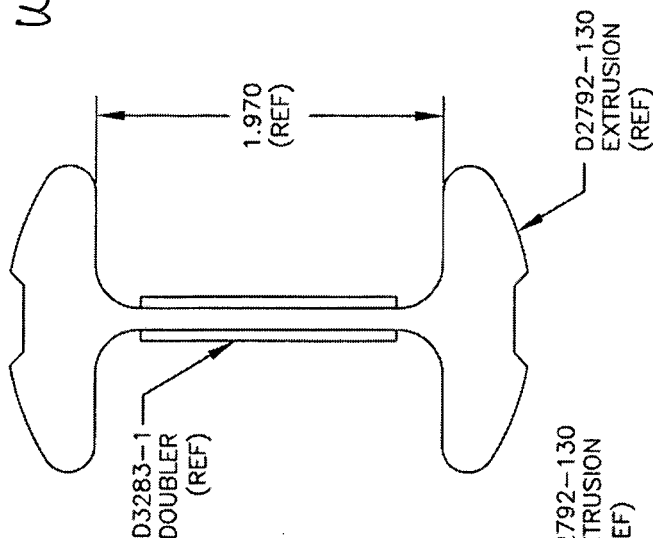
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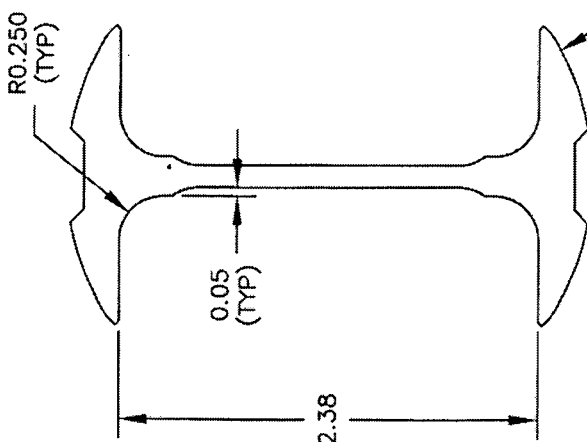


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3282	REV. C
		TITLE	FLOAT WEB, 206L/407	SHEET 2 OF 2
				SCALE
				1:20

SECTION B-B

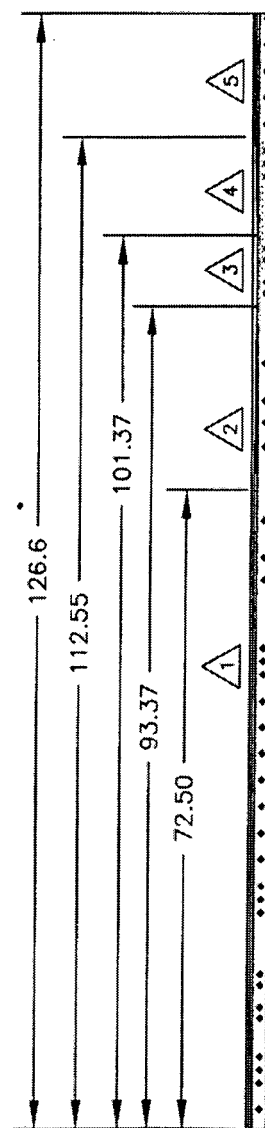


SECTION A-A



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1.
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED

05.04.12

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